

Work Order ID 149984

August 18, 2016 3:07:04 PM

149984

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Item ID: D120-637-011 Repair Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access Step™, LH
 Start Date: 8/17/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/18/2016 Req'd Qty: 1.00 ***1*** Customer: CEURO24
 Reference: RMA RA112308

Approvals: Process Plan: SJA Date: AUG 19 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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100		0.00							
100									
QC	Memo	0.00							DAS 9 9-89
Quality Control	INSPECT D120-637-011 REPAIR B14917 X 1 ON RA 112308								

110		0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing	SCUFF ENTIRE STEP								

115	QC5- Inspect part completeness to step on W/O	0.00							
115									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D120-637-011	CHG	CHG003
DESC	7050A3321019	STC	
LOT	B14917	STC	
MODEL	EC 120	STC	

B#149984 x 1 LH

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Item ID: D120-637-011 Repair

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step™, LH

Start Date: 8/17/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/18/2016 Req'd Qty: 1.00 ***1***

Customer: CEURO24

Reference: RMA RA112308

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Powdercoat									
Powder Coating	Memo MB4858. RE POWDER COAT	0.00							START: 8:30 OV. T: 300° FINISH: 9:00
125	QC3- Inspect Part Finish	0.00							
125									
QC									
Quality Control	Memo	0.00							
130		0.00							
130									
HandFinish									
Hand Finishing	Memo 8#M135317 RE DO WING-WALK	0.00							

DAS 34 9-89

DAS 15 9-89

BEB.

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Item ID: D120-637-011 Repair

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access Step™, LH

Start Date: 8/17/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/18/2016 Req'd Qty: 1.00

1

Customer: CEURO24

Reference: RMA RA112308

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control	INSPECT COMPLETENESS OF KIT AS PER CHG 003 <i>Kit in QC office.</i>								P.T.O.
136	Identify as per dwg & Stock Location: <i>Eg</i>	0.00							
136									
Packaging	Memo	0.00							
Packaging	ID AS REPAIR, ADD NEW PAPERWORK AND RETURN TO CUSTOMER								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1608-22 PD.

IX **DAS 28 9-89** **AUG 23 2016**

DAS 21 9-89 **AUG 30 2016**
dem 16/08/23

DQA:

Date: 09/22/2016

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date: SEP 01 2016

Work Order update only

Work Order: 149984	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D120-637-011 Repair		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. 16-5995		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☒	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data	16-08-22	PS	1	B* on D2616-1 was not available	DAS 9 9-89	Scrap D2616-1 from D120-637-011 B14917 and replace with new one D2616-1 B130632 P47 qty 1.		PD 16-08-22	DAS 9 9-89
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☒ Other
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no traceability

Picklist Print

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Work Order ID: 149984

149984

Parent Item: D120-637-011 Repair

D120-637-011 Repair

Parent Item Name: Heli-Access Step™, LH

Start Date: 8/17/2016

Required Date: 8/18/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D120-637-011 Repair		Manufactured	No				Each	0.0000		1			
D120-637-011 Repair									**				
Heli-Access Step™, LH													

DAS
9
289

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MEY	APPROVED BW	DRAWING NO. D120-637	REV. E SHEET 1 OF 6
DATE 97.09.24		TITLE EC120 HELI-ACCESS-STEP	SCALE NTS
A	96.10.23	ORIGINAL ISSUE	
B	97.02.17	CHANGE FRONT MOUNT	
C	97.05.01	CHANGE AFT MOUNT TO CLEAR FAIRING	
D	97.05.19	CHANGE FRONT MOUNT	
E	97.09.24	CHANGE STEP LENGTH	

Qty -011	Qty -012	Qty -041	Qty -042	Part Number	Description
X				D120-637-011	STEP INSTALLATION LH
	X			D120-637-012	STEP INSTALLATION RH
1		X		D2610-041	STEP ASSEMBLY LH
	1		X	D2610-042	STEP ASSEMBLY RH
8	8			D2274	RADIUS BLOCK
2	2			D2615-1	MOUNTING LUG
1				D2616-1	MOUNTING LUG (LH)
	1			D2616-2	MOUNTING LUG (RH)
1	1			D2617-3	BUSHING
2	2			D2617-5	SPACER
2	2			D2618	BUSHING
1	1			D2619-041	COVER
		1	1	D2674-3	NUT PLATE
		1		D2678-041	STEP WELDMENT LH
			1	D2678-042	STEP WELDMENT RH
2	2			D2679	MOUNTING CLAMP
2	2			D2681	CLAMP
		1	1	D2682-041	SUPPORT PLATE
		1	1	D2683-041	FRONT MOUNT PLATE
4	4			AN4-11A	BOLT
1	1			AN4-14A	BOLT
2	2			AN4-16A	BOLT
2	2			AN5-36A	BOLT
3	3			AN526C832R8	SCREW
3	3			AN960JD8	WASHER
		2	2	AN960JD10L	WASHER
14	14			AN960JD416	WASHER
4	4			AN960JD516	WASHER
		2	2	MS20426AD3-5	RIVET
7	7			MS21042L4	NUT (OR MS21042-4)
2	2			MS21042L5	NUT (OR MS21042-5)
		2	2	MS24693-S272	SCREW (OR MS24693-C272)
		2	2	MS27039-1-09	SCREW
		5	5	M7885/3-4-3	RIVET (OR CR3212-4-3)

**EUROCOPTER**

AN EADS COMPANY

DEFECTIVE / DEFECTUEUX

OPR 1037 C - Code article SAP/ID Produit : 1101890

QN Number:
(Numéro Avis Qualité)

201067 068

QIR Number:
(Numéro PVE)*Designation:
(Désignation)

Marche Pied G

Date:

le 01-08-2015

EC Part Number:
(Référence EUROCOPTER)

7050A3321 019

S/N:

(Numéro de Série)

H/C n°:
(N° Hélicoptère)

MUGNIER Sébastien

Surname - First name:
(Nom et prénom du rédacteur)Department:
(Département du rédacteur)

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